

Date: Wednesday, 1/30/2008 8:02:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL MOUNT ANGLE
Job Number : 37102	
Estimate Number : 10780	
P.O. Number :	Part Number : D32083
This Issue : 1/30/2008 S.O. No. :	Drawing Number : D3208 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 32804	Material :
Written By : <u> </u>	Due Date : 2/11/2008 Qty: 12 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est: B 04.05.25 Material changed for Step 4 KJ/JLM	
Est Rev: C Now on Waterjet 06-10-12 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.0692 sf(s)/Unit Total : 0.8303 sf(s)
 6061-T6 .063 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Batch: 105225 B 8-1-31

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3208
 Dwg Rev: A1
 Prog Rev: A1

B 8-1-31

12

2-Deburr if necessary

B 8-1-31

08/01/31 12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 8-1-31

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/01/31 12

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Deburr D3208-3
 Form D3208-3 as per Dwg D3208
 Polish any marks on part within 01. of Dwg D3208

08/02/11 12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 28/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 8:02:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL MOUNT ANGLE

Job Number: 37102

Part Number: D32083

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/11 (412)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-02-12

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

AS

08/02/13

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 200

AS

08/02/13

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.02.13

Job Completion



08.02.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

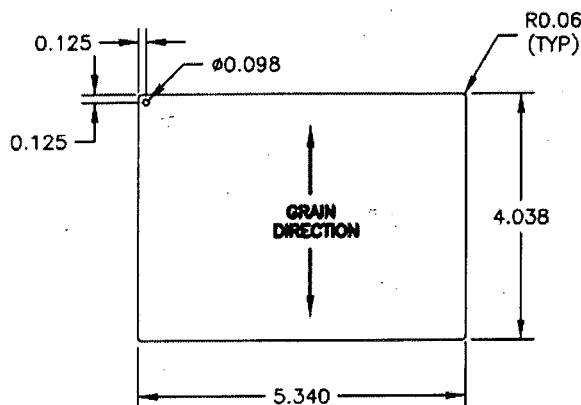
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

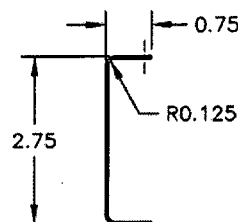


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CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	# 04.05.25	CHANGE DIM; NOTE 3) CHANGE	

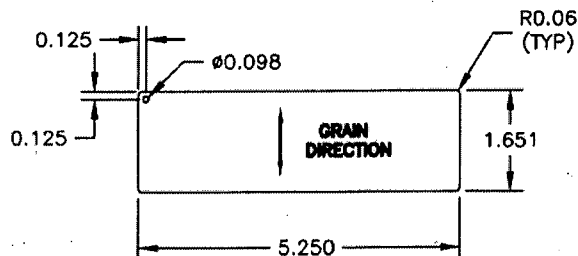
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04.04.05



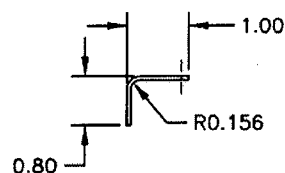
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

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WORK ORDER
NO. 37102

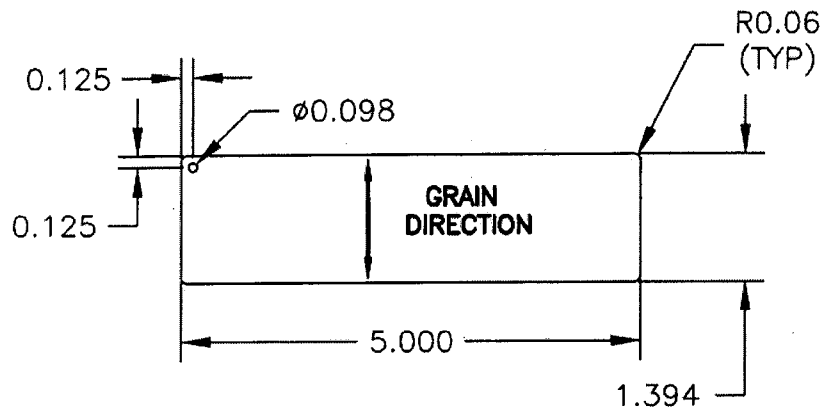
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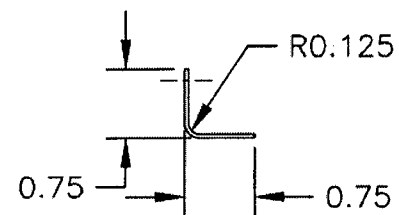
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED
04.04.05 H

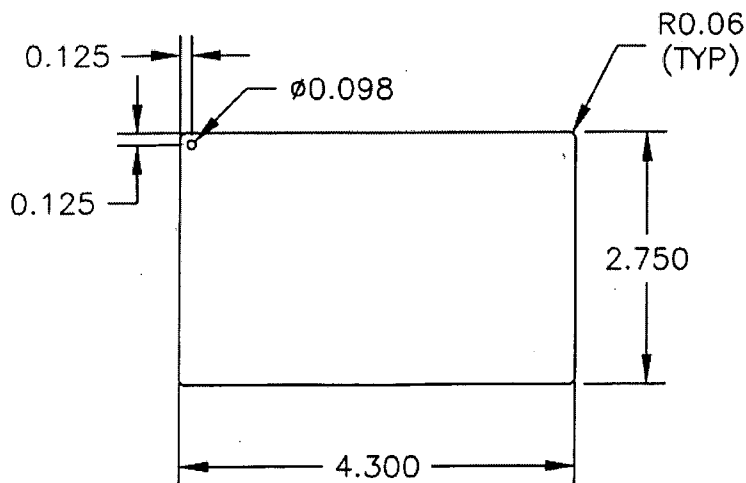


2

**D3208-5 MOUNT ANGLE
FLAT PATTERN**

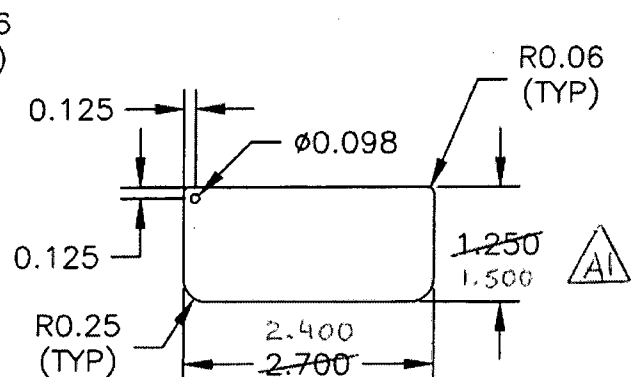


**D3208-5 MOUNT ANGLE
BEND DETAIL**



2

D3208-7 FILLER



2

D3208-11 FILLER

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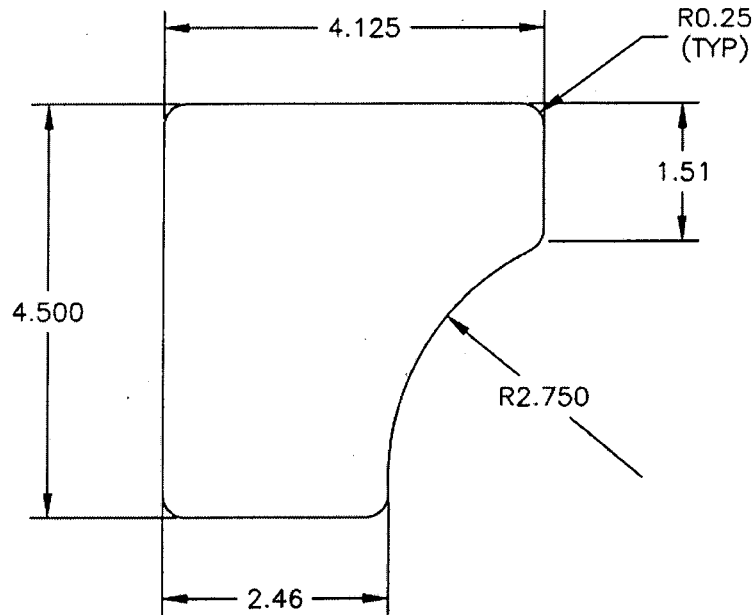
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05 [Signature]



D3208-9 DOUBLER

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